

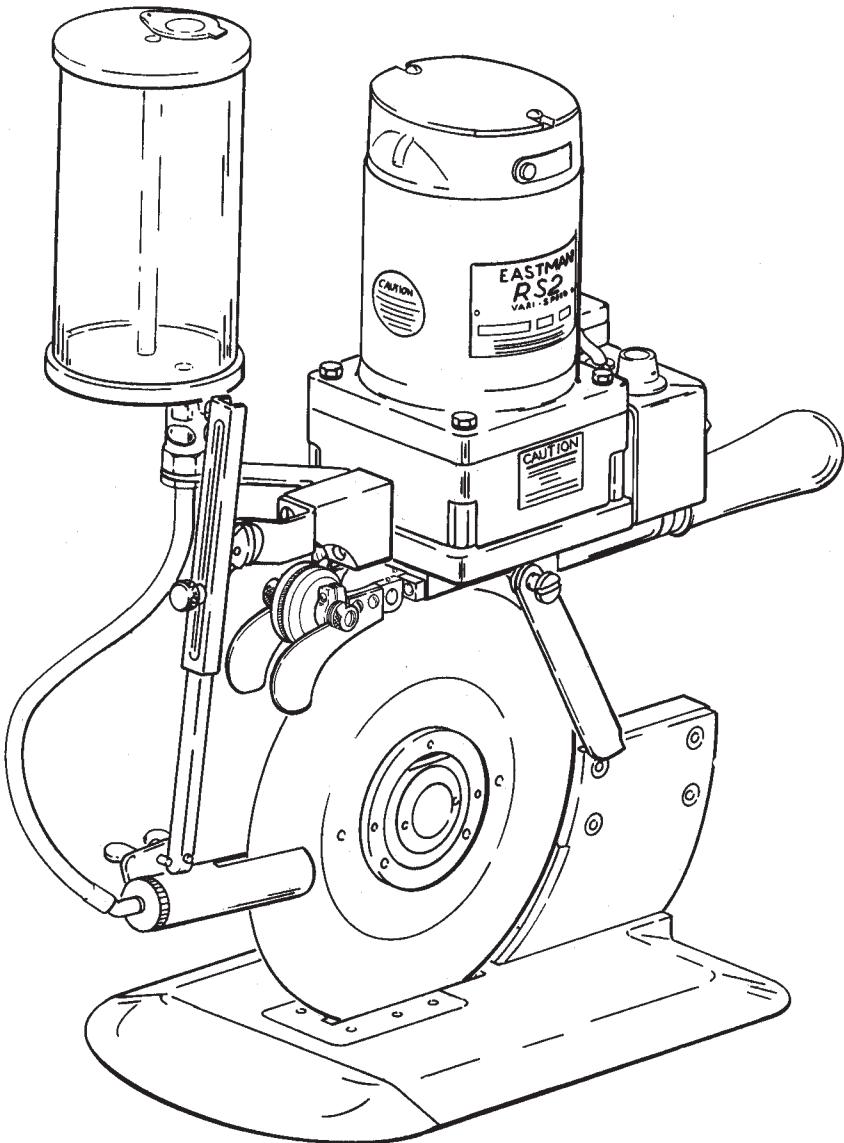
Eastman®

RUBBER SLITTER

MODEL RS2

! WARNING

Safety glasses must be worn at all times when operating or servicing this equipment.



Please read completely before attempting to operate your new **RS2** Cutting Machine.

! WARNING

This machine is equipped with a very sharp knife. Keep hands, arms, and hair away from the knife area at all times.

Misuse of this machine or failure to follow all safety instructions on this machine and in the instruction manual may result in serious personal injuries.

Instruction Book and Parts List

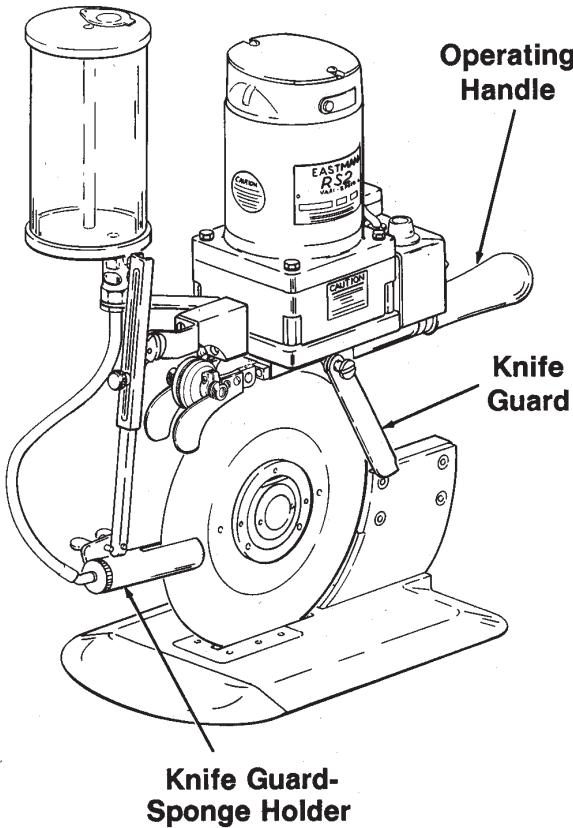
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CustomerService@EastmanCuts.com

Eastman®

779 Washington St., Buffalo, N.Y. 14203-1396 U.S.A. • (716)856-2200 • Fax (716)856-1140 or (716)856-2068
Manufacturers of Eastman Cutting and Spreading Machines
www.EastmanCuts.com

Eastman® Operation, Lubrication And Care

Before operating machine, read these instructions carefully. Familiarize yourself with all functions and adjustments of this equipment.



The purchaser must instruct all operators on the proper use of the equipment. All standard industrial safety measures and equipment should be provided to protect the operator. Operators must be cautioned that improper use of this equipment can cause bodily injury. If you do not have qualified operators to instruct new persons, contact your Eastman sales representative or write to Eastman Machine factory direct.

CAUTION

Read instructions carefully before starting motor. Be sure that voltage and current are the same as stamped on nameplate. This machine is equipped with sharp blade and extreme caution should be used when this machine is put into use. Use control levers and handles only when operating or handling machine. When making a cut, the knife guard should be raised only enough to clear the material being cut. When machine is not in operation the front knife guard should be kept in the lowered position and lubricator turned off. When this equipment is not being utilized, the power supply should be disconnected from the equipment.

OPERATING INSTRUCTIONS

Loosen thumb screw for adjustment of knife guard and sponge holder. Raise guard enough to clear material to be cut. Turn sight tube valve counterclockwise for lubrication of knife. Switch machine to ON position, if cutter does not start immediately, return switch to OFF position. Check the line output and be sure the unit is plugged in properly and is making full contact. Then repeat procedure. DO NOT attempt to start this unit while in material to be cut. After knife has gathered full speed, material can now be cut. To keep friction and heat build up to a minimum a combination of low speed and flow of lubricant are used. The blade speed setting, depending on operator preference, can be decreased by turning the speed control knob counterclockwise to a lower number (0 = 65 RPM) or increase by turning clockwise to a higher setting (10 = 150 RPM).

Limited Warranty. Eastman warrants to the buyer that the *RS2 Rubber Slitter* shall be free from defects in materials or workmanship for a period of 90 days commencing on the date of invoice. Any goods or parts claimed by the buyer to be defective must be returned to Eastman, freight charges prepaid, within the 90-day warranty period. If Eastman determines that the goods or parts are defective in materials or workmanship, Eastman's sole obligation under this warranty shall be, at Eastman's sole option, to repair or replace the defective goods or parts or to provide the buyer a credit equal to the portion of the purchase price allocable to the defective goods or parts. This warranty shall not apply if defects are caused by product misuse or neglect, if the machine has been altered or modified by the buyer, or if other than genuine Eastman parts are used in the machine. **THIS WARRANTY IS THE ONLY WARRANTY APPLICABLE TO THIS PURCHASE. SELLER DISCLAIMS ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.**

Limitation of Liability. Eastman's liability to the buyer, and the buyer's remedies from Eastman, whether in contract, negligence, tort, under any warranty or otherwise, shall be limited to the remedies provided in the foregoing Limited Warranty. In no event shall Eastman have any responsibility or liability to the buyer for (a) any special, indirect, incidental, or consequential damages, including, but not limited to, loss of use, revenue, or profit, even if Eastman has been advised of the possibility of such damages, or (b) any claim against the buyer by any third party. The price stated for the product sold is a consideration for limiting Eastman's liability.

OPTIONAL

The RS2 Rubber Slitter has been designed for quick and easy conversion between the standard Baseplate and the optional Strip Gauge. To make the conversion; disconnect the power attachment plug. Remove (5) screws, (308C15-2) and (308C15-3) between the bracket and standard. The new strip gauge can now be mounted using the same (5) screws and ready for use in minutes as shown on page 18. Strip gauge operation is identical to that of the standard Baseplate with the added advantage of a Strip Gauge for cutting strips up to 11" wide and 1 1/2" thick.



WARNING

Before performing any of the following procedures, make sure that the attachment plug has been disconnected from power source.

MAINTENANCE PROCEDURES

1. Be sure the baseplate rollers are kept lint free.
2. Be sure the terminal pins on the terminal block are in good condition to make full contact with the female receptacle.
3. Inspect the operating switch periodically for full contact when in the ON position.
4. When replacing the knife on this cutting unit, remove any lint build-up between the knife and the standard.
5. If the cutting unit seems to lag while not cutting, the knife should be removed and the unit should be run without the knife to see if the machine has been over greased or if there is an obstruction somewhere.

KNIFE SHARPENING

Take the machine out of material to be cut. Switch machine to ON position, note setting of variable speed and increase speed to full capacity. To obtain a fine, keen edge on blade, press lightly on sharpener lever with a constant pressure. Hold lever until blade is sharp, then release. Return variable speed setting to cutting speed.

TO REPLACE THE KNIFE

Loosen thumb screw and slide guard to upward position. Turn the knife so the small hole lines up with hole in the standard and insert knife removal pin (17C11) into hole. Loosen three (3) setscrews in the locknut and remove the locknut that retains the blade with the special spanner wrench (95C1-13). When installing a new knife, be sure the name Eastman Machine Company is facing outward and the knife seats on the knife gear. Install knife locknut and secure setscrews. Secure guard in operating position. Refer to page 13 for replacement knives.



CAUTION:

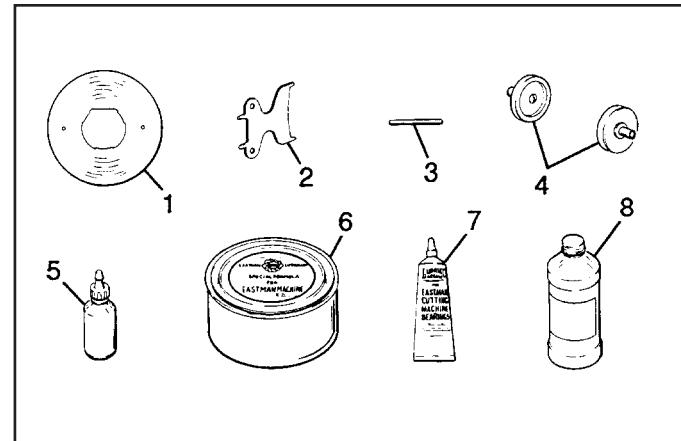
Discard used sharp knives with care.



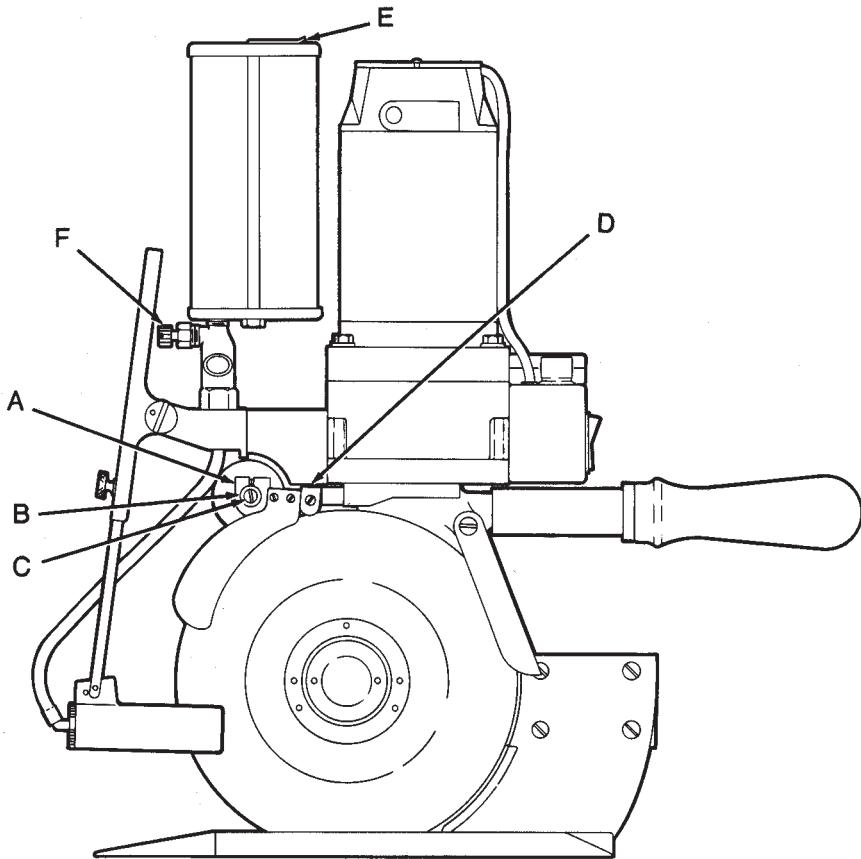
CAUTION

Do not use sewing machine oil or detergent oil. It is entirely too light for cutting machine lubrication. For best results use specially compounded Eastman Oil. Do not oil Base Plate Rollers.

Maintenance Supplies			
ITEM	PART NO.	DESCRIPTION	QTY.
1	See Page 11	Knives	1
2	95C1-13	Spanner Wrench	1
3	17C11	Knife Removal Pin	1
4	See Page 12	Emery Wheels	1
5	242C1	Eastman Oil	1
6	242C2	Eastman Gear Lubricant	1
7	242C2-2	Eastman Lubriko Bearing Grease	1
8	See Page 15	Plastic Master Fluid	1



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LUBRICATION

DO NOT USE AN EXCESS AMOUNT OF OIL

Twice A Day

Oil emery wheel spindles at "C" with specially compounded Eastman Oil (242C1).

Once A Day

Lubricate gears. Screw grease cup down one-half turn. Refill cup, as required with Eastman Gear Lubricant special formula (242C2).

Once A Month

Grease Knife gear bearing. Remove bearing locknut with spanner wrench and use a small amount of Eastman Lubriko grease (242C2-2) from tube.

LUBRICATION

With electrical cord disconnected, fill water can assembly at "E" with diluted EASTMAN Concentrated PLASTIC MASTER FLUID (242C3-0 or 242C3-3). Fluid must be diluted with plain water before use. Add two ounces of fluid with one gallon of water. Shake or stir thoroughly.

SPONGE REPLACEMENT

With electrical cord disconnected and sight tube valve "F" turned off, remove sponge holder cap from holder as shown on page 17. Remove sponge. Install new sponge and secure cap. Place sponge holder in working position to continue operation.

NOTICE

The Eastman Machine Company does not warrant this Plastic Cutting Fluid and disclaims all liability for any damage that may occur through its use.

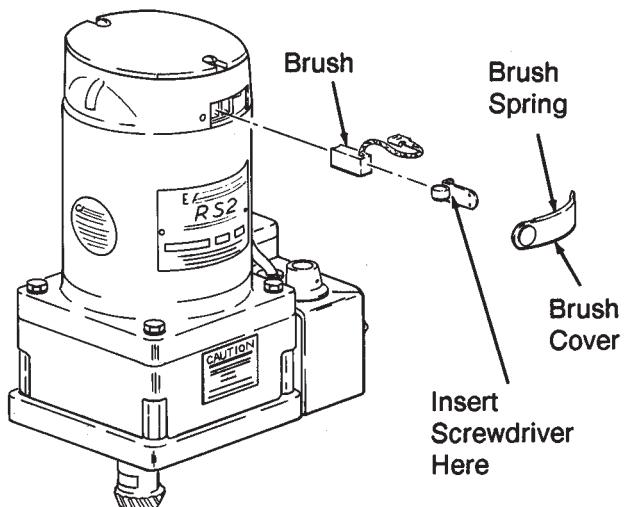
TO ADJUST EMERY WHEELS

As the Emery Wheels wear away and become farther apart, they must be adjusted. Emery Wheels must be adjusted from both sides to assure proper centering of the wheels over the knife.

To adjust, loosen slotted head screws "A". With fingers, turn adjusting bushings "B" until Emery Wheels are as close together as possible without touching and are centered over the knife. Both wheels should grind at the same time when pressed lightly against the knife and there should be no more than 1/32 inch clearance between the two Emery Wheels. Tighten slotted head screws "A".

TO REPLACE EMERY WHEELS

With front of machine facing serviceman, guard rod in down safe position, remove right hand grinding wheel and arm by loosening setscrew "D" and sliding arm off shaft. Remove slotted head screw "C" and replace grinding wheel with spindle in right hand arm. Do not remove left hand arm from machine. Remove slotted head screw "C" from left hand arm and replace grinding wheel with spindle. Re-assemble right hand arm to shaft and adjust wheels to knife as described above.



MOTOR BRUSH REPLACEMENT

With electrical cord disconnected, unsnap Brush Cover (53C11-165) from motor and remove cover. Remove Brush Spring (34C1-62) from brush holder by pushing in, then release. Gently pull brush wire to remove Brush (708C1-18) and check for wear. If brush is less than 3/8" in length, brush must be replaced. Disconnect terminal from tab on motor.

Before inserting new brushes, use air hose or bellows with proper eye protection and blow dust out of motor. When inserting new brushes, brush wire must face slot in brush holder. Connect brush terminal to tab on motor. Place brush spring in guide with spring facing brush. With small screwdriver slide clip down and lock clip in place, as shown. Snap brush cover in place.

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Eastman® Illustrated Parts List

Your Eastman **RS2** Rubber Slitter Round Knife has been carefully designed to provide many hours of trouble free operation. The comprehensive exploded parts illustrations have been carefully prepared to enable you to easily order replacement parts, as required. Replacement parts for this machine may be ordered thru your nearest Eastman representative or directly from the Eastman factory.

IMPORTANT:

Always specify machine model and serial number when ordering parts for faster more efficient service.

Index

EXPLODED PARTS ILLUSTRATIONS

The exploded part illustrations and part lists in this section have been divided into major assemblies as follows:

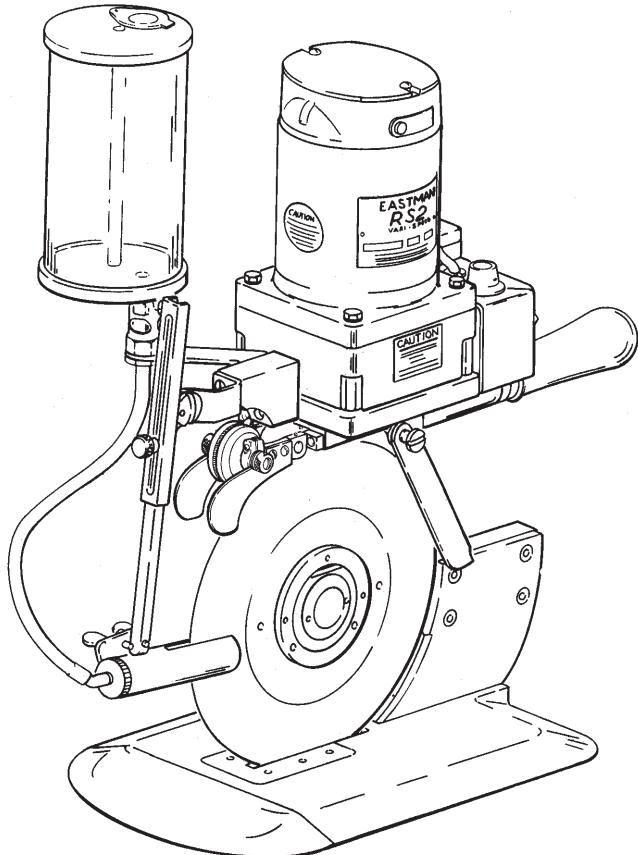
Knife Replacement	Page 3
Motor Assembly & Control Box	Page 8
Electrical Upgrade Kit	Page 10
Standard Assembly	Page 12
Sharpener Assembly	Page 14
Moistening Attachment & Guard Assembly	Page 16
Baseplate Assembly	Page 18
Service Record	Page 23
Terminal Block, Attachment Plug	Page 24

OPTIONAL

Stationary Baseplate Assembly	Page 18
Strip Guage	Page 20
Motor Mounting Bracket	Page 22

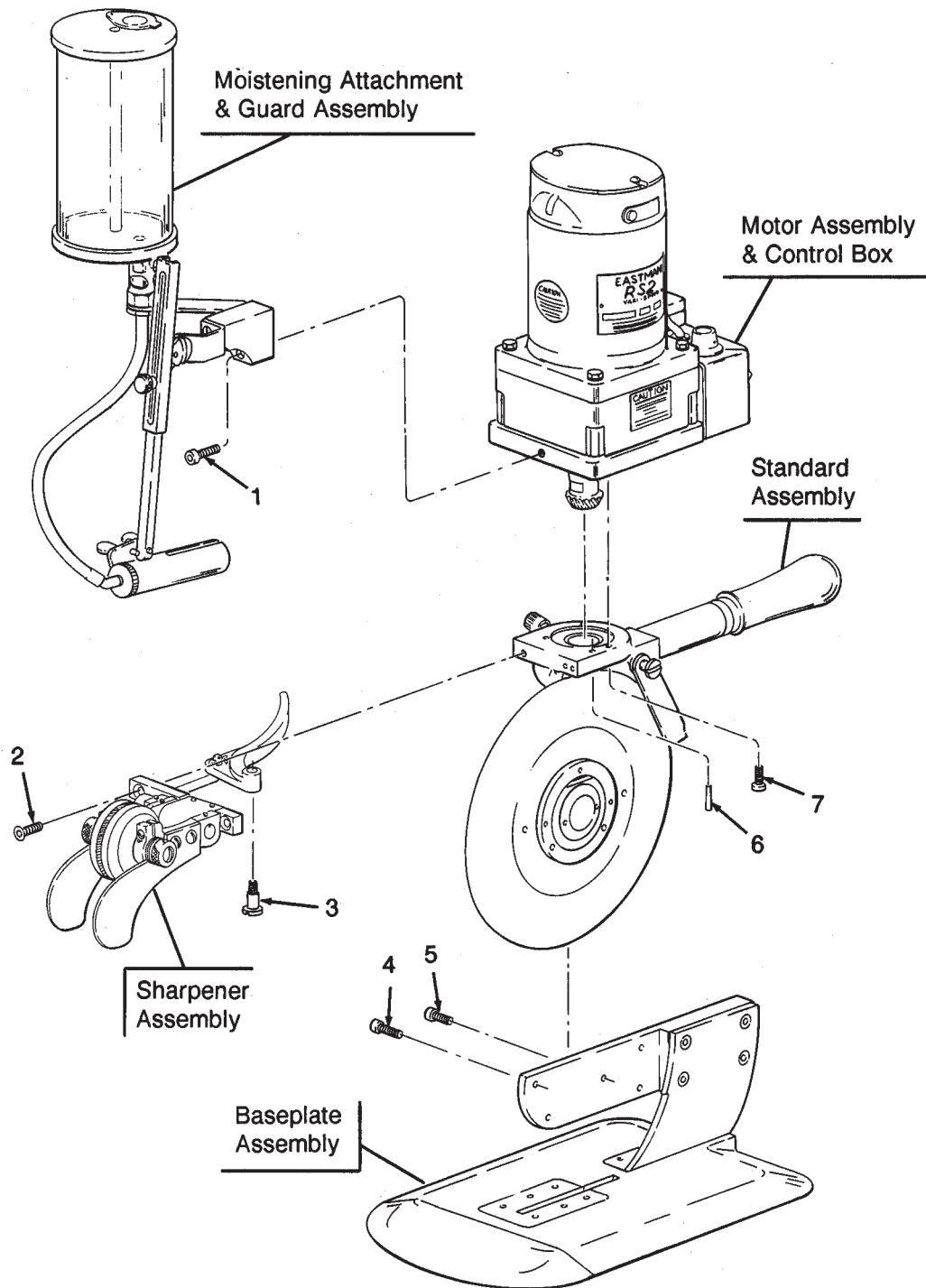
NOTE:

Three different abrasive Emery Wheel grits (designed to provide you with a selection of edges) may be ordered for this machine. See page 12 of this manual for more information.



NOTE: Please specify model and serial number of machine when ordering parts. Item numbers are for reference only. Please specify PART NUMBERS when ordering replacement parts.

ITEM	PART NO.	DESCRIPTION	QTY.
1	308C18-1	Screw, Socket Hd. Cap 1/4-20 x 1	1
2	302C12-5	Screw, Flat Hd. Cap 8-32 x 1/2	2
3	20C8-2	Screw	1
4	308C15-3	Screw, Socket Hd. Cap 10-32 x 3/8	2
5	308C15-2	Screw, Socket Hd. Cap 10-32 x 1/2	3
6	17C1-4	Pin, Taper	1
7	308C14-4	Screw, Socket Hd. Cap 10-24 x 3/4	3



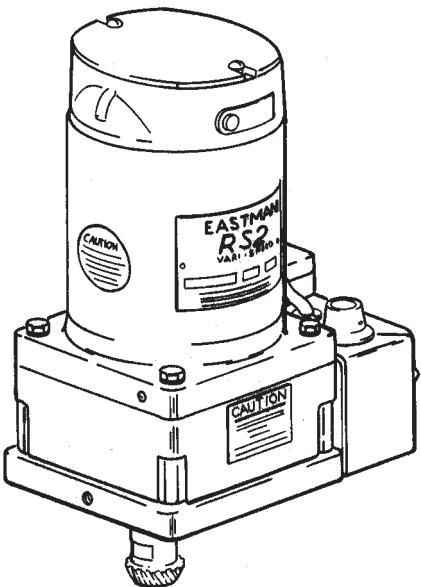
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Motor Assembly &

Control Box

Illustrated Parts List



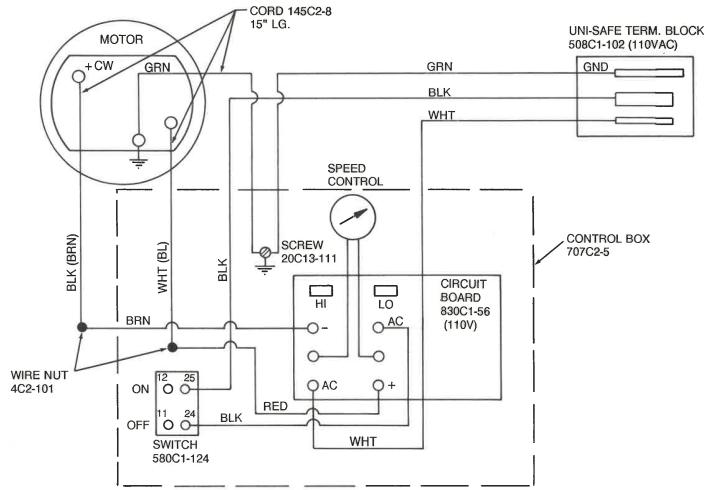
ITEM	PART NO.	DESCRIPTION	QTY.
1	517C1-1215	Gear Motor, STD, 110V/220V	1
	517C1-1290	Gear Motor, HD, 110V/220V	
2	79C2-61	Label, Caution Sharp Blade	1
3	79C2-62	Label, Caution	1
4	300C7-1	Screw, Round Hd. Cap 4-36 x 1/8	1
5	254C1-2	Tie Mount	1
6	145C2-8	Cord #18-3 Wire	1
7	254C1	Cable Tie	1
8	21C14-19	Bushing, Strain Relief	1
9	199C1-11	Lug Ring	3
10	4C2-101	Nut, Wire Connector	2
11	308C20-116	Screw, Socket Hd. Cap 1/4-28 x 1	4
12	608C1-20	Intermediate Gear w/o Bearing (Includes 87C1-31 Gear)	1
	608C1-21	Intermediate Gear w/Bearing (Includes 87C1-31 Gear)	1
13	12C11-18 A	Washer, Spacer (.002 Thick)	A/R
	12C11-18 B	Washer, Spacer (.003 Thick)	A/R
	12C11-18 C	Washer, Spacer (.004 Thick)	A/R
	12C11-18 D	Washer, Spacer (.005 Thick)	A/R
	12C11-18 E	Washer, Spacer (.010 Thick)	A/R
14	29C6-171	Adaptor, Motor	1
15	305C8-1	Screw, Binding Hd. 4-40 x 1/4	2
16	12C1-35	Washer	2
17	308C12-2	Screw, Socket Hd. Cap 8-32 x 1/2	2
18	783C1-10	Ground Wire Assembly	1
19	20C13-111	Screw, Grounding 10-32 x 3/8	1
20	104C1-6	Dial Indicator	1
21	830C1-56	Speed Control (110V)	1
22	4C2-106	Nut, Hex #4-40	2
23	8C13-87	Insulation	1
24	182C14-9	Control Box	1
25	306C80-201	Screw, Pan Hd. 8-18 x 3/8	4
26	580C1-124	Switch, 1 Phase	1
27	708C1-18	Motor Brush (Not Shown)	2
28	34C1-62	Brush Spring (Not Shown)	2
29	53C11-165	Brush Cover (Not Shown)	2
	53C11-178	Brush Cover for Metal Top	2

NOTE:

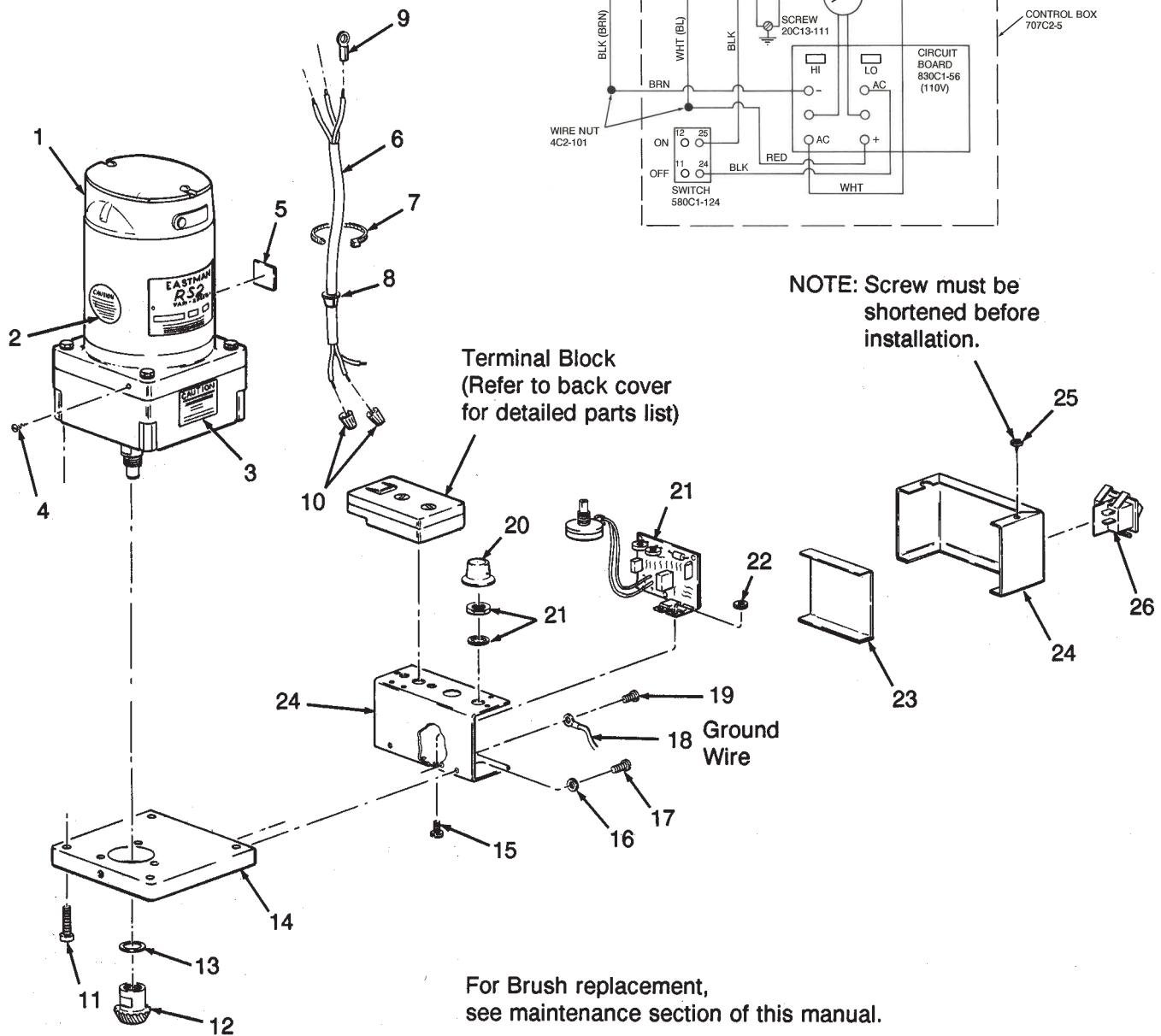
Please specify model and serial number of machine when ordering parts.
 Item numbers are for reference only.
 Please specify PART NUMBERS when ordering replacement parts.

A/R-As Required

WARNING: Terminal Block must be grounded. Attach ground wire to ground terminal "E" on terminal Block.



NOTE: Screw must be shortened before installation.



For Brush replacement,
see maintenance section of this manual.

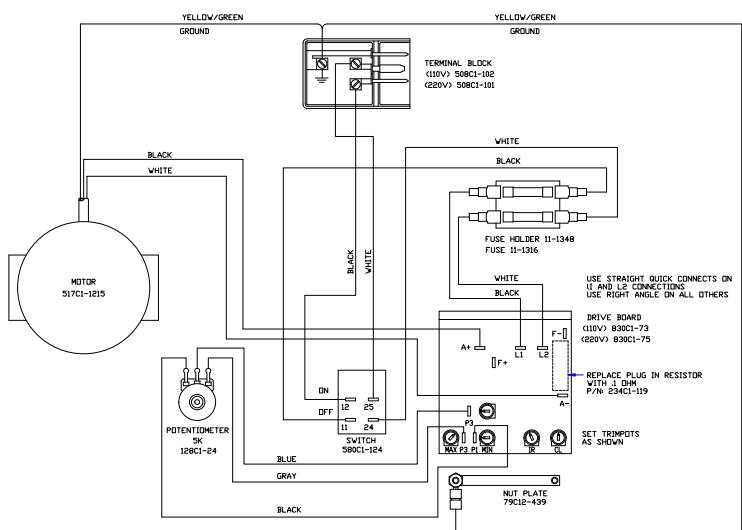
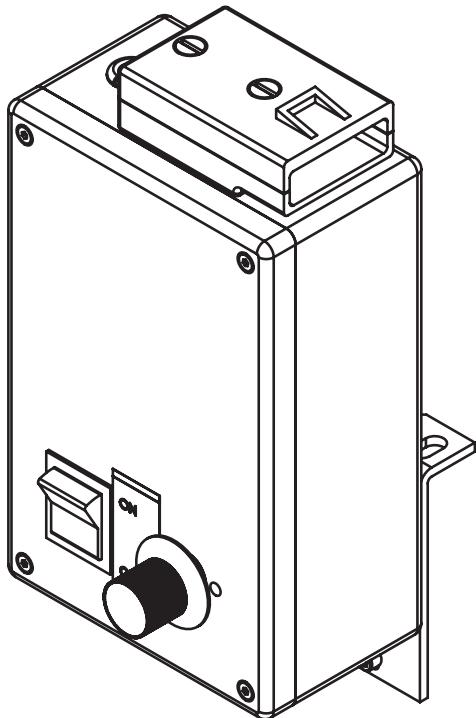
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Electrical Upgrade Kit

820C4-5

Illustrated Parts List (After 1/20/2002)



DWG No. 668C1-263

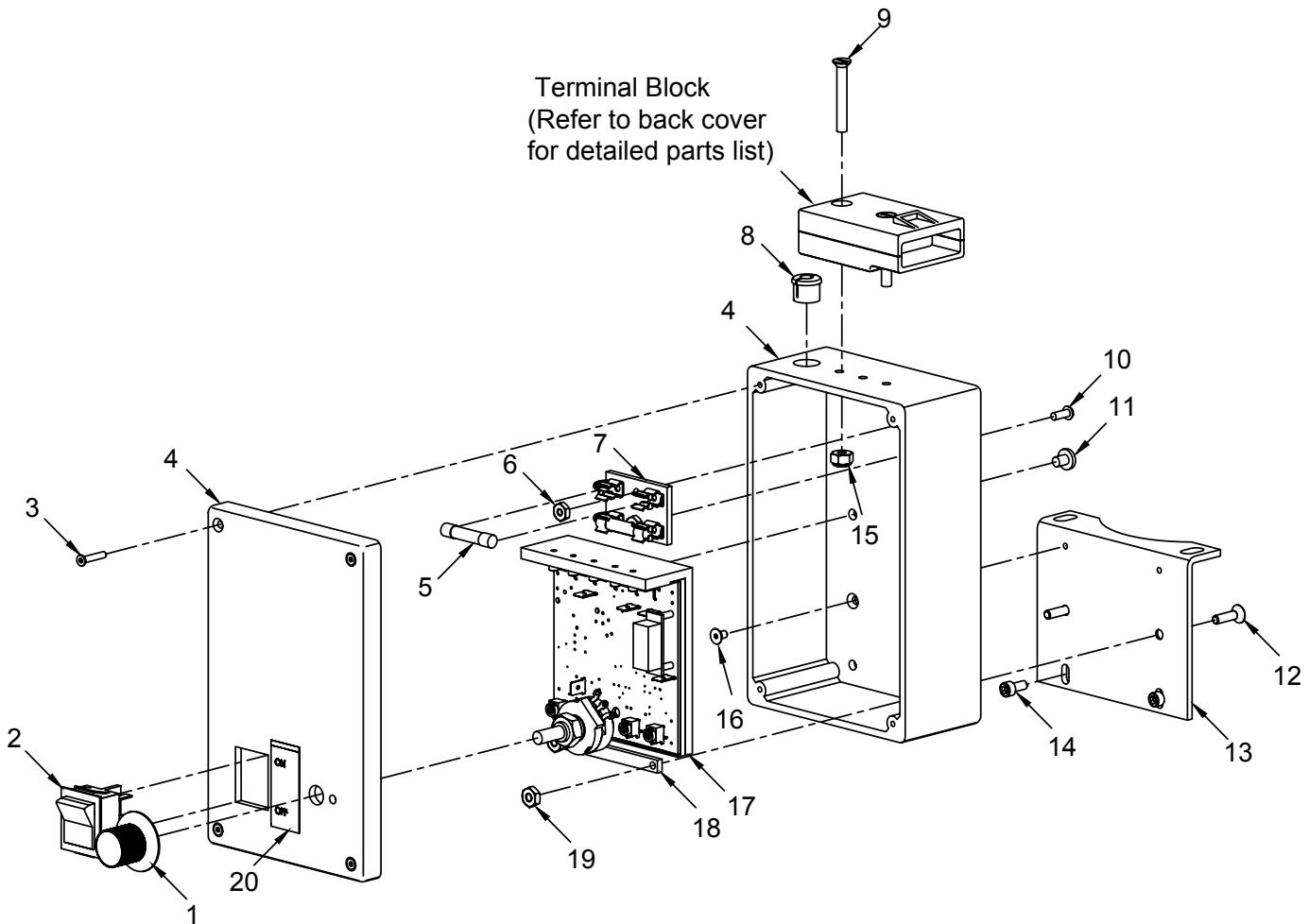
ITEM	PART NO.	DESCRIPTION	QTY
1	104C1-6	Dial Indicator	1
2	580C1-124	Switch Dpst, Rocker 16A-250VAC	1
3	332-M3-16	Screw, Socket Flat Head M3 x 0.5 x 16	4
4	182C14-14	Control Box	1
5	11-1316	Fuse, 2 Amp	2
6	4C2-82	Nut, Hex #6-32	2
7	11-1348	Fuse Holder, 2 Position	1
8	21C14-19	Bushing, Strain Relief	1
9	302C15-10	Screw, Flat Head #10-32 x 1&3/8	2
10	313-86-6	Screw, Round Head #6-32 x 3/8	2
11	305C15-2	Screw, Binding Head #10-32 x 1/4	2
12	332-93-10	Screw, Socket Flat Head #8-32 x 5/8	2
13	62C16-343	Mounting Bracket	1
14	308C12-1	Screw, Socket Head #8-32 x 3/8	2
15	211-102	Nut, Elastic Hex #10-32	2
16	332-86-4	Screw, Socket Flat Head #6-32 x 1/4	2
17	830C1-73	Speed Control, 110V	1
	830C1-75	Speed Control, 220V	
18	79C12-439	Nut Plate	1
19	4C2-110	Nut, Elastic Stop #8-32	2
20	236C1-137	Label, On/Off	

Please specify model and serial number of machine when ordering parts.

Item numbers are for reference only.

Please specify PART NUMBERS when ordering replacement parts.

WARNING: Terminal Block must be grounded. Attach ground wire to ground terminal "E" on terminal Block.

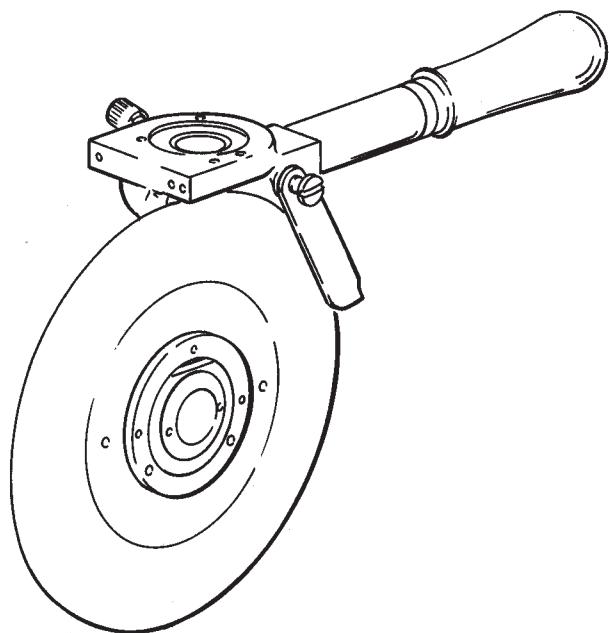


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Standard

Assembly

Illustrated Parts List



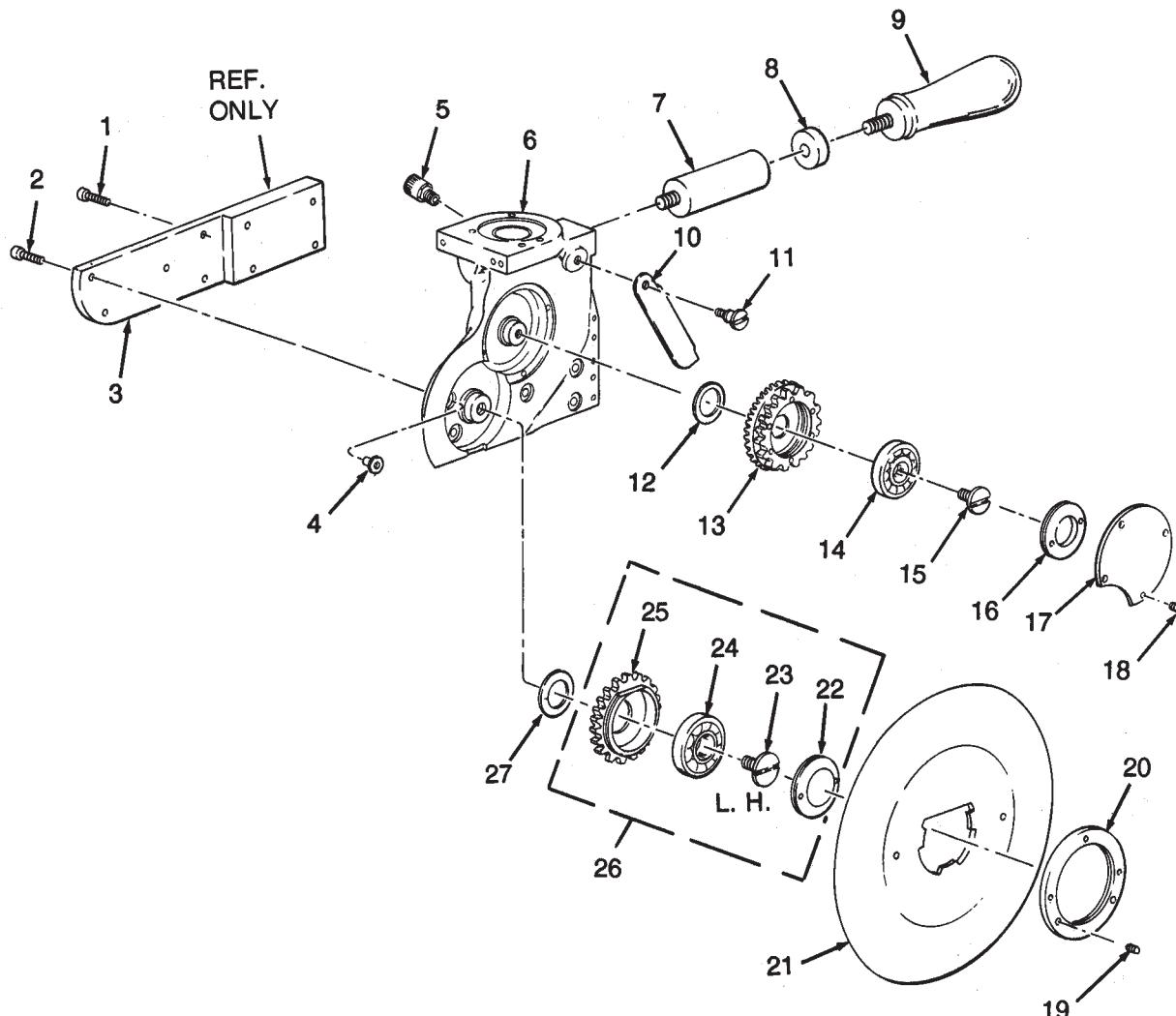
ITEM	PART NO.	DESCRIPTION	QTY.
1	308C15-2	Screw, Socket Hd. Cap 10-32 x 1/2	3
2	308C15-3	Screw, Socket Hd. Cap 10-32 x 3/8	2
3	79C12-247	Bracket, Ref. Only	1
4	4C2-133	Insert Nut 10-32	5
5	72C4-20	Cup, Grease	1
6	88C1-184	Standard	1
7	29C6-173	Adaptor, Operating Handle	1
8	4C1-111	Locknut, Handle	1
9	531C1-53	Handle	1
10	25C4-157	Knife Guard	1
11	20C7-1	Screw, Thumb	1
12	12C9-8	Gear Spacing Washer	1
13	608C1-20	Intermediate Gear w/o Bearing (Includes 87C1-31 Gear)	1
	608C1-21	Intermediate Gear with Bearing (Includes 87C1-31 Gear)	1
14	90C6-9	Internal Gear Bearing	1
15	20C4-26	Screw, Bearing Lock	1
16	4C1-103	Locknut, Internal Gear	1
17	53C4-52	Cover, Gear	1
18	302C7-2	Screw, Flat Hd. 4-36 x 1/4	4
19	309C12-3	Setscrew, 8-32 x 3/16	3
20	4C1-178	Locknut, Knife	1
21	*	7 1/2 Knife	1
22	4C1-113	Locknut, Knife	1
23	20C4-30	Screw, Lock	1
24	90C6-33	Bearing, Knife	1
25	87C2-25	Gear, Knife	1
26	521C1-26	Knife Gear Assembly	1
27	12C9-7 A	Washer, Spacer (.002 THK)	A/R
	12C9-7 B	Washer, Spacer (.003 THK)	A/R
	12C9-7 C	Washer, Spacer (.004 THK)	A/R
	12C9-7 D	Washer, Spacer (.005 THK)	A/R
	12C9-7 E	Washer, Spacer (.010 THK)	A/R
	12C9-7 F	Washer, Spacer (.020 THK)	A/R

A/R-As Required

* See Table

NOTE:

Please specify model and serial number of machine when ordering parts.
Item numbers are for reference only.
Please specify PART NUMBERS when ordering replacement parts.



**For best results use only
GENUINE
EASTMAN Knives**

The guarantee covering your RS2 Round Knife is not valid if knives other than those manufactured by Eastman are used.

**7 $\frac{1}{2}$ " DIAMETER
ROUND KNIFE SELECTION CHART**

80C1-77	Carbon Steel
80C1-77G	Carbon Steel, Grooved
80C1-77HS	High Speed Steel
80C1-77HSG	High Speed Steel, Grooved

Teflon coated knives available.

Order by adding "T" to end of knife number.

⚠️ WARNING

When cutting with the standard baseplate the knife must be reversed. The name will face the outside.

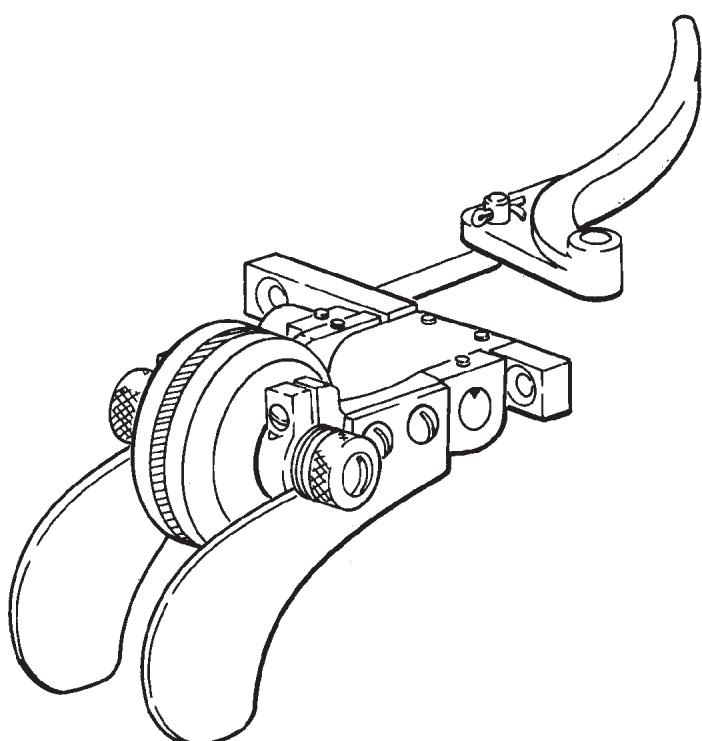
When cutting with optional strip gauge the knife must be reversed. The name will be on the inside.

See page 15 for sharpener modification.

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Sharpener Assembly

Illustrated Parts List



ITEM	PART NO.	DESCRIPTION	QTY.
1	57C2-22	Sharpener Lever	1
2	20C8-2	Screw	1
3	17C15-71	Cotter Pin, 1/16 x 1/2	2
4	77C1-34	Link, Sharp Contact	1
5	34C1-20	Spring, Tension	1
6	309C12-3	Setscrew, 8-32 x 3/16	2
7	46C3-13	Block, Sharpener Arm	1
8	11C10-19	Shaft, Sharpener	1
9	25C4-163	Knife Guard	2
10	540C1-51 LH	Arm with Wheel L.H. (120 Grit)	1
11	540C1-52 RH	Arm with Wheel R.H. (120 Grit)	1
12	309C12-1	Setscrew, 8-32 x 3/16	2
13	636C1-13	Sharpener Bracket	1
14	12C15-29	Washer, Flat	2
15	35C5-57	Arm, Sharpener	1
16	300C8-8	Screw, Round Hd. 4-40 x 5/16	4
17	300C10-5	Screw, Round Hd. 6-32 x 7/16	2
18	304C10-3	Screw, Truss Hd. 6-32 x 3/16	2
19	20C6-11	Screw, Bushing	1
20	541C1-9	Emery Wheel Ass'y(120 Grit)	2
	541C1-13	Emery Wheel Ass'y(150 Grit)	2
	541C1-21	Emery Wheel Ass'y(220 Grit)	2
21	92C1-12	Spindle	1
22	12C15-70	Washer	1
23	133C1-12	Emery Wheel (120 Grit)	2
	133C1-14	Emery Wheel (150 Grit)	2
	133C1-25	Emery Wheel (220 Grit)	2
24	12C1-28	Washer, Lock	1
25	20C13-20	Screw, Oval Hd. 8-32 x 5/16	1
26	300C12-3	Screw, 8-32 x 3/8	1
27	12C1-21	Lock Washer	1
28	35C5-65	Sharpener Arm	1

NOTE:

Please specify model and serial number of machine when ordering parts.
Item numbers are for reference only.
Please specify PART NUMBERS when ordering replacement parts.

LH-Left Hand
RH-Right Hand



Warning

When interchanging Base Plate and Optional Strip Gauge, the following changes must be performed:

1. With Standard Base Plate (page 18) the blade is used with the EASTMAN name facing outward. The operator can then see the Eastman name.

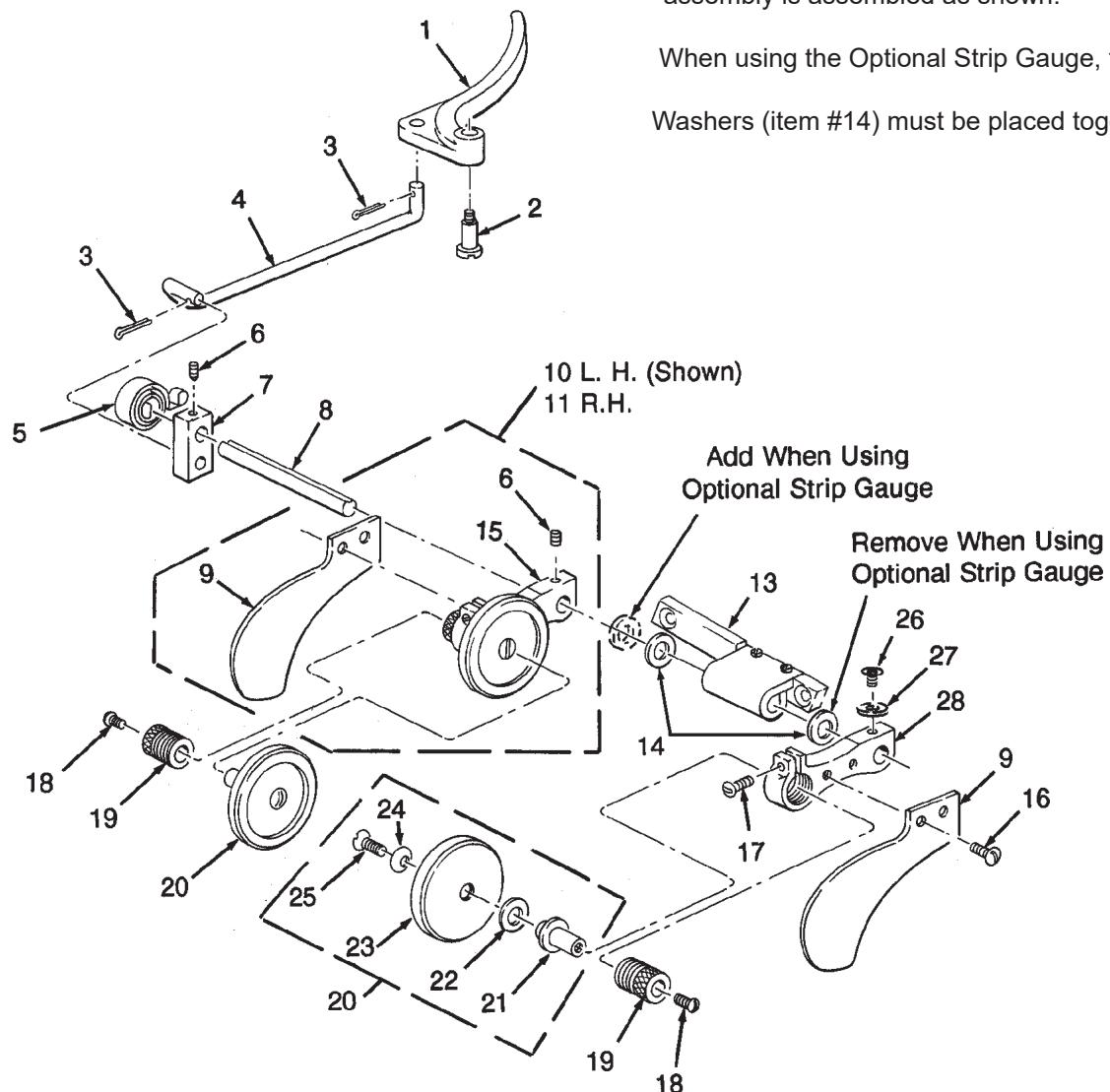
When using the optional Strip Gauge, the blade is used with the EASTMAN name facing in. The operator will not see the EASTMAN name.

2. Sharpener modifications:

When using Standard Base Plate the sharpener assembly is assembled as shown.

When using the Optional Strip Gauge, the

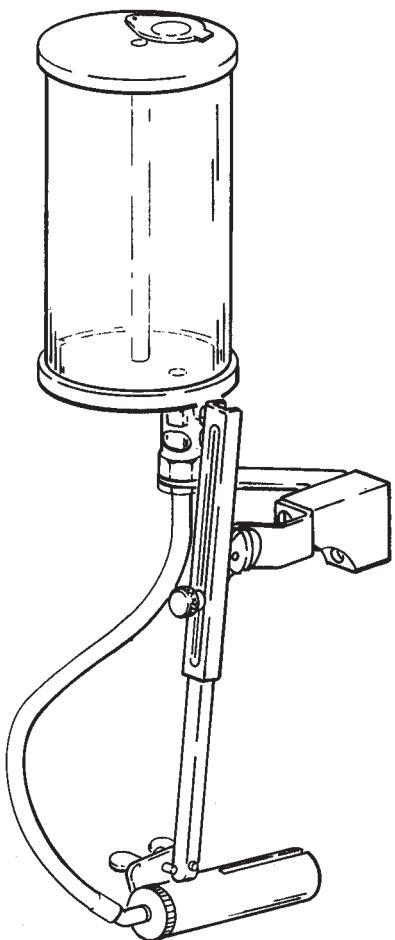
Washers (item #14) must be placed together.



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Moistening Attachment & Guard Assembly

Illustrated Parts List



ITEM	PART NO.	DESCRIPTION	QTY.
1	741C1-10	Water Can Assembly	1
2	53C11-69	Cover, Water Can	1
3	91C4-11	Rivet	1
4	720C1-32	Rod & Disc Top Assembly	1
5	12C15-61	Gasket	2
6	140C1-1	Body, Water Can	1
7	115C1-12	Disc, Bottom	1
8	12C15-63	Washer, Flat Rubber	1
9	12C15-60	Washer, Flat	1
10	4C1-152	Locknut	1
11	671C2-1	Valve, Sight w/Tube	1
12	73C7-41	Tube, Rubber	1
13	300C12-6	Screw, Round Hd. 8-32 x 1/2	2
14	62C16-116	Bracket, Water Can	1
15	4C2-93	Nut, Elastic Spline	1
16	300C12-6	Screw, Round Hd. 8-32 x 1/2	2
17	62C9-85	Bracket, Guard	1
18	29C6-172	Adaptor, Guard	1
19	33C4-26	Holder Guard	1
20	20C4-38	Screw, Guard	1
21	17C15-123	Roll Pin, 3/32 x 5/16	1
22	20C5-2	Screw	1
23	65C2-18	Rod, Knife Guard	1
24	33C10-29	Sponge Holder	1
25	20C12-80	Screw, Sponge Holder	1
26	191C1-29	Sponge, 75X	1
27	86C7-17	Cap, Sponge Holder	1
28	73C7-31	Tube, Moist Device	1

NOTE:

Please specify model and serial number of machine when ordering parts.

Item numbers are for reference only.

Please specify PART NUMBERS when ordering replacement parts.

GENUINE EASTMAN
Concentrated PLASTIC MASTER FLUID

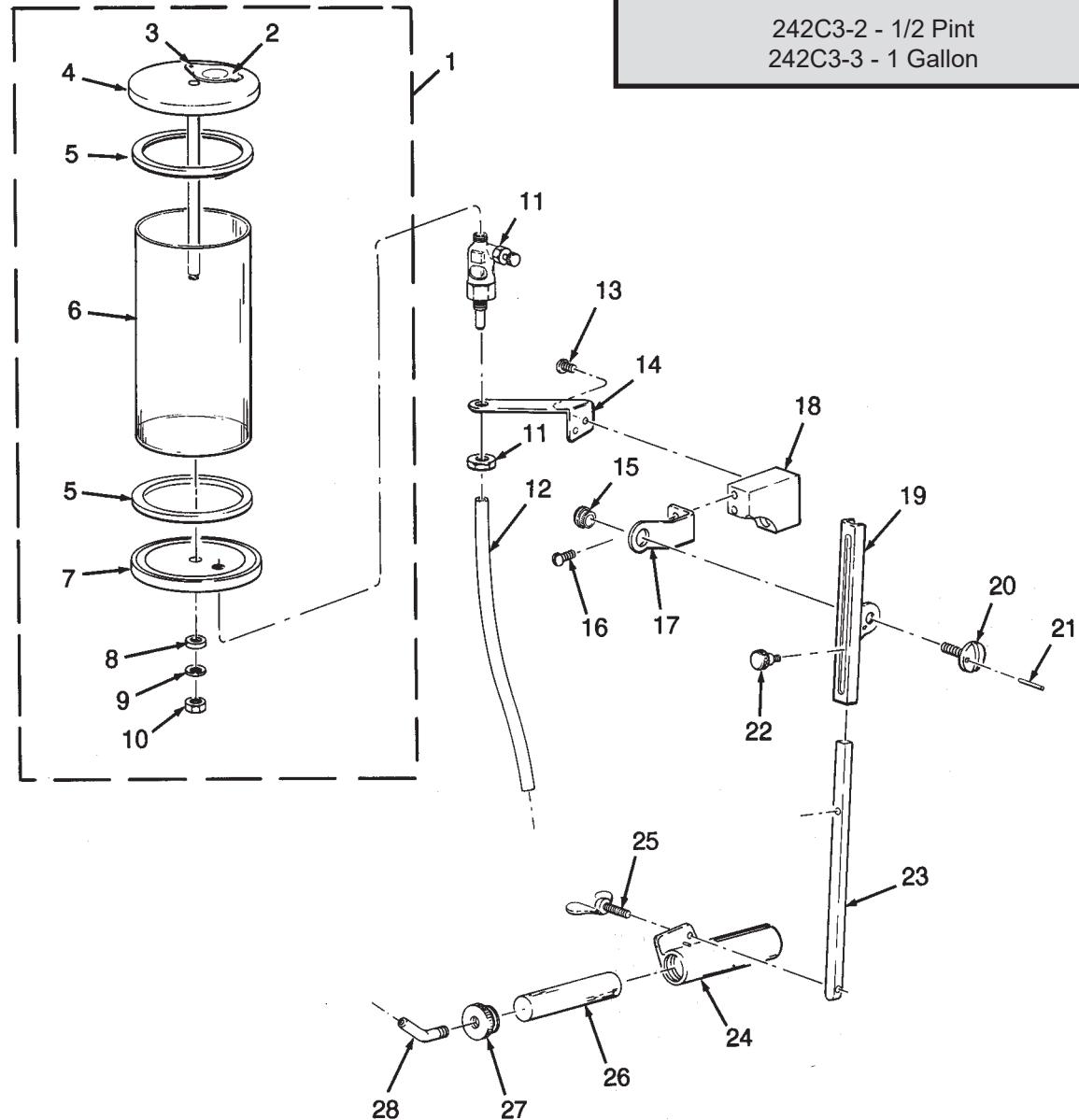
242C3-0 - 1/2 Pint

242C3-1 - 1 Gallon

GENUINE EASTMAN
Concentrated PLASTIC MASTER FLUID
for Rubber Products

242C3-2 - 1/2 Pint

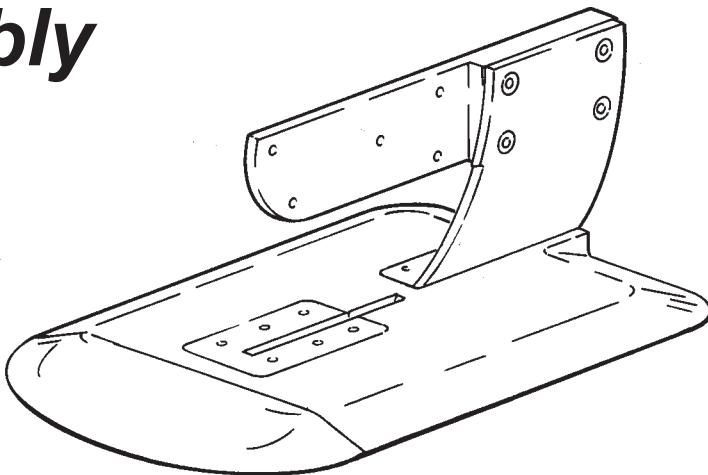
242C3-3 - 1 Gallon



Eastman®

Baseplate Assembly

Illustrated Parts List



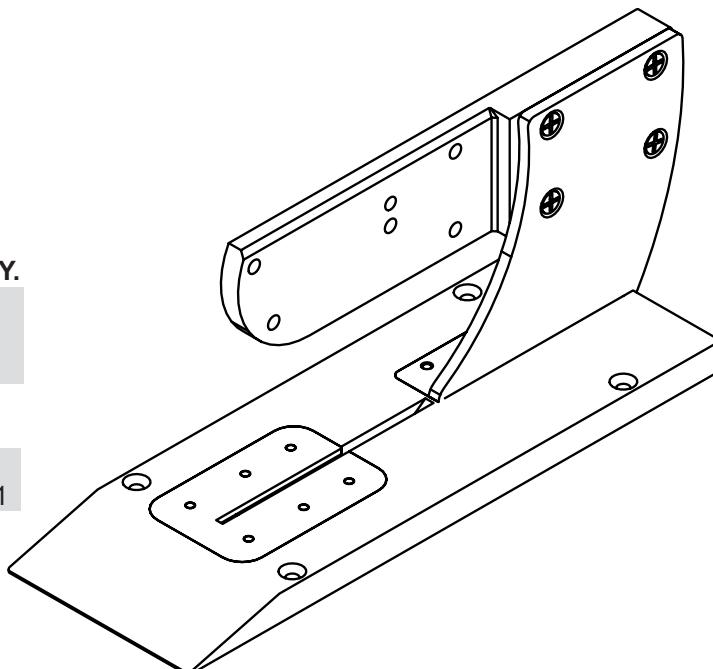
ITEM	PART NO.	DESCRIPTION	QTY.
1	79C12-247	Bracket	1
2	62C16-226	Bracket for Standard	1
3	302C15-4	Screw, Flat Hd. 10-32 x 5/8	4
4	505C3-230	Plate Base, Complete	1
5	79C5-264	Plate, Throat	1
6	300C12-2	Screw, Round Hd. 8-32 x 1/4	2
7	300C12-5	Screw, Round Hd. 8-32 x 7/16	4
8	300C12-3	Screw, Round Hd. 8-32 x 3/4	5
9	622C1-4	Roller Plate (Front)	2
10	41C2-7	Roller Plate	10
11	12C8-1	Washer, Plate Roller	2
12	61C1-5	Shell, Plate Roller	1
13	11C2-13	Shaft, Plate Roller	1
14	98C4-11	Clip, Roller Shaft	4
15	302C10-1	Screw, Flat Hd. 6-32 x 3/16	8

ITEM	PART NO.	DESCRIPTION	QTY.
16	59C1-151	Plate, Flat 75X	1
17	619C1-8	Roller Plate (Rear)	1
18	12C8-1	Washer, Plate Roller	4
19	41C2-7	Roller Plate	20
20	61C1-5	Shell, Plate Roller	2
21	11C2-14	Shaft, Plate Roller	1
22	20C5-12	Screw	4
23	17C6	Pin, Hinge	2
24	60C1-14	Wing Plate	1

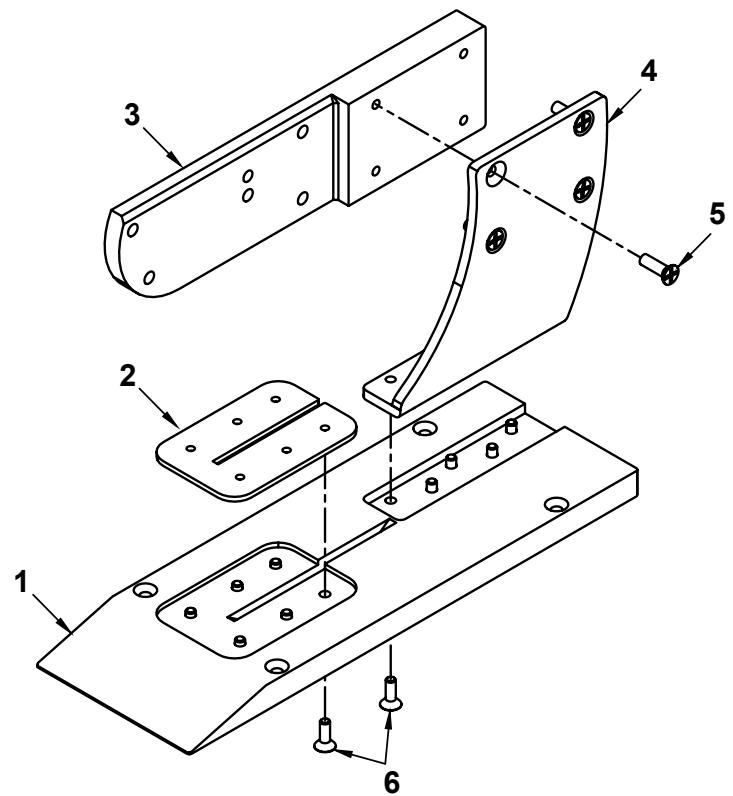
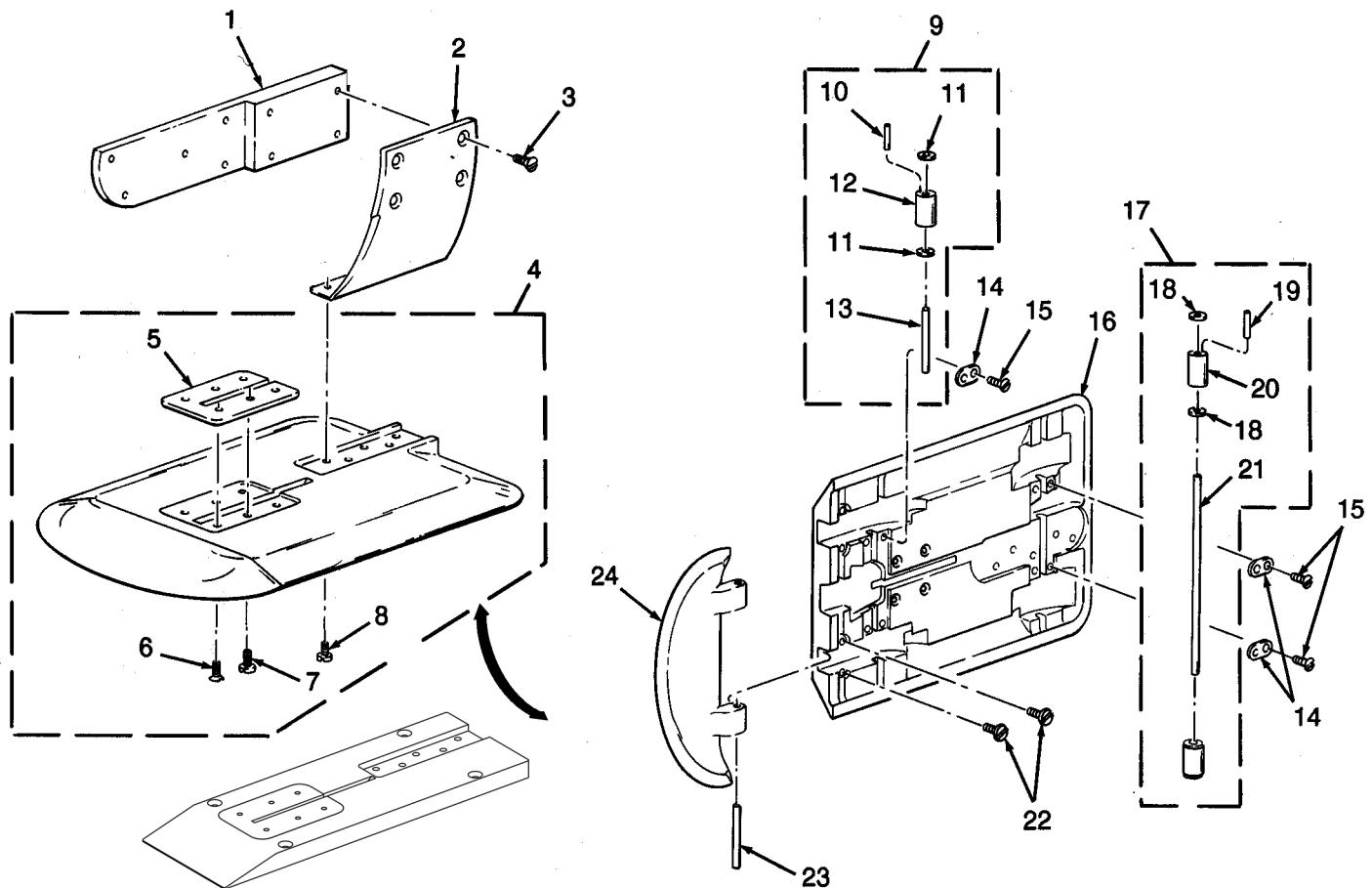
Stationary Baseplate Assembly

(Optional)

Illustrated Parts List



ITEM	PART NO.	DESCRIPTION	QTY.
1	59C3-143	Stationary Baseplate	1
2	79C5-264	Plate Throat	2
3	79C12-247	Bracket	1
4	762C16-226	Bracket for Standard	1
5	302C15-4	Screw, Flat Hd. 10-32 x 5/8	4
6	332-93-8	Screw, Socket Flat Head 8-32 x 1/2	11



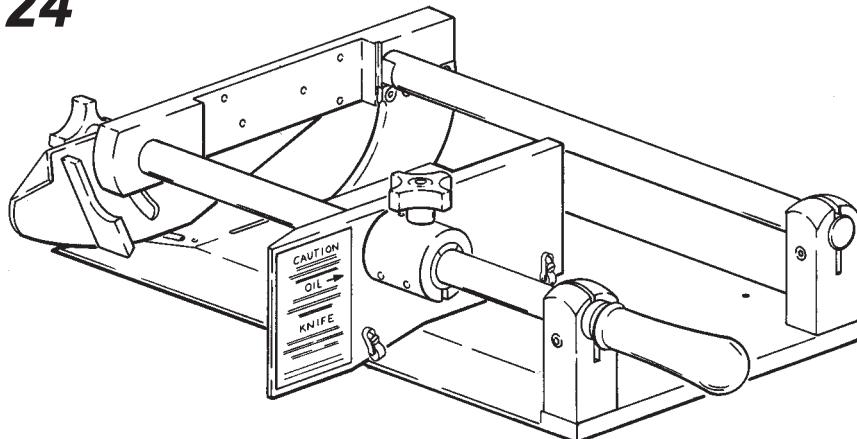
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Strip Gauge (optional)

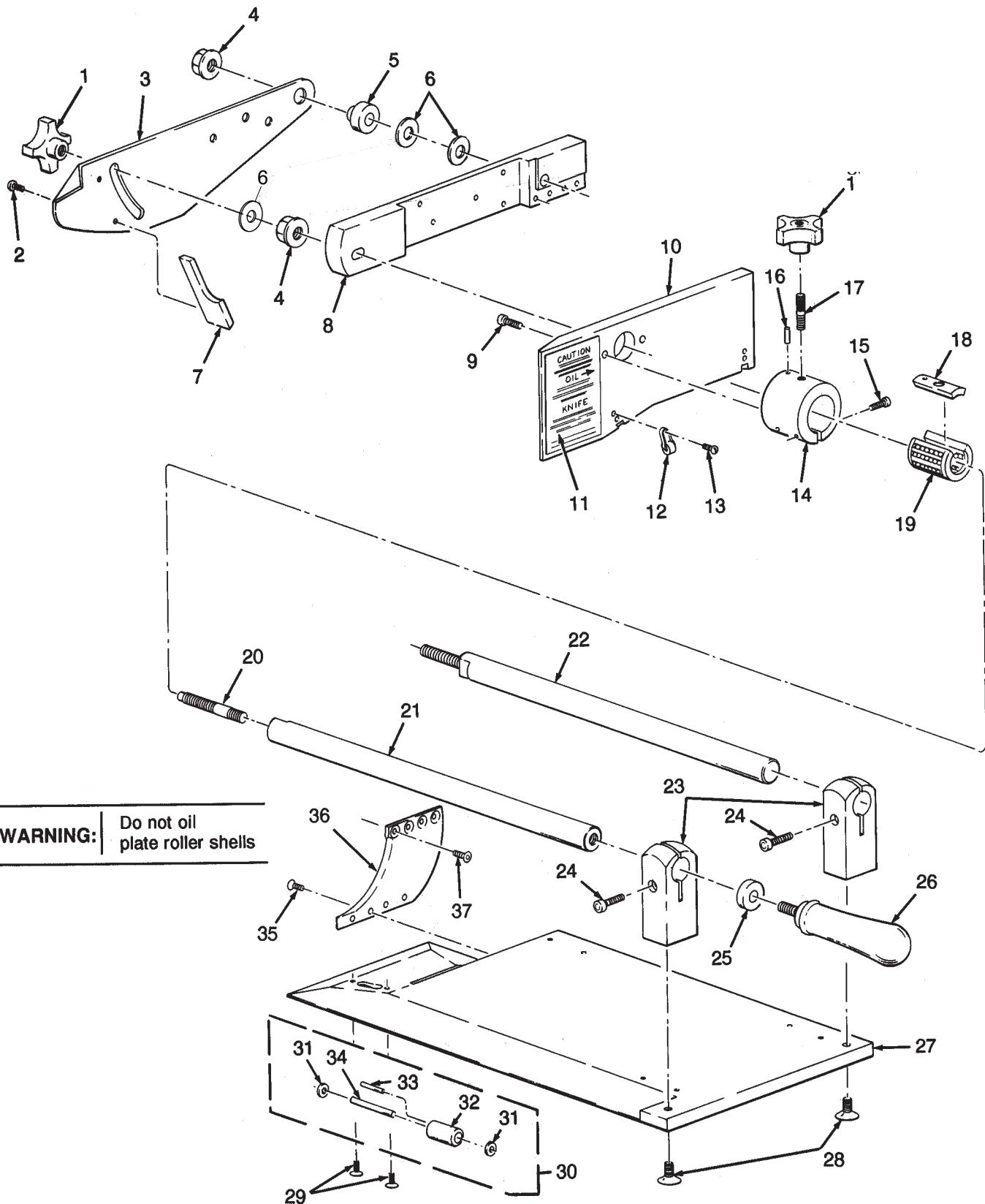
505C2-98 - 11"

505C2-98A - 18"

505C2-98B - 24"



ITEM	PART NO.	DESCRIPTION	QTY.	ITEM	PART NO.	DESCRIPTION	QTY.						
1	13C2-15	Knob, Hand, Aluminum	2	21	11C12-121	Bearing Shaft, 11"	1						
2	313-86-6	Screw, Round.Hd.#6-32 X 3/8	2	21	11C12-121A	Bearing Shaft, 18"							
3	25C4-178	Lower Side Guard	1	21	11C12-121B	Bearing Shaft, 24"							
4	4C2-134	Nut, Flange 3/8-16	2	22	11C12-122	Shaft, Support, 11"	1						
5	55C4-147	Spacer	1	22	11C12-122A	Shaft, Support, 18"							
6	12C15-46	Washer, Flat 5/16	3	22	11C12-122B	Shaft, Support, 24"							
7	25C4-179	Lower Front Guard	1	23	189C1-24	Post, Gauge Support	2						
8	79C12-403	Plate, Standard to Bracket	1	24	308C21-4	Screw, Socket Hd. 5/16-18 x 1	2						
9	308C15-1	Screw, Socket Hd. 10-32 x 5/8	2	25	4C1-111	Locknut, Handle	1						
10	59C1-172	Guide Plate	1	26	531C1-53	Handle, Operating	1						
11	236C1-111	Label, Instruction	1	27	59C1-171	Base Plate, 11"	1						
12	728C1-5	Stabilizer Assembly	2	27	59C1-171A	Base Plate, 18"							
13	305C8-2	Screw, Binding Hd. 4-40 x 3/8	4	27	59C1-171B	Base Plate, 24"							
14	62C16-306	Gage Brg., Lock Bracket	1	28	320C23-216	Screw, Flat Hd. 3/8-16 x 1	2						
15	308C15-5	Screw, Socket Hd. 10-32 x 3/4	2	29	320C15-1	Screw, Flat Hd. 10-32 x 3/8	8						
16	17C15-126	Roll Pin 1/8 x 1/2	1	30	622C1-4	Roller Plate	4						
17	15C13-60	Stud	1	31	12C8-1	Washer, Plate Roller	2						
18	171C1-22	Gauge Lock	1	32	61C1-5	Shell Plate Roller	1						
19	90C6-63	Bearing, Linear	1	33	41C2-7	Roller Plate	10						
20	15C13-63	Stud, 3"	1	34	11C2-13	Shaft, Plate Roller	1						
NOTE:		Please specify model and serial number of machine when ordering parts. Item numbers are for reference only. Please specify PART NUMBERS when ordering replacement parts.											
()-Not shown													



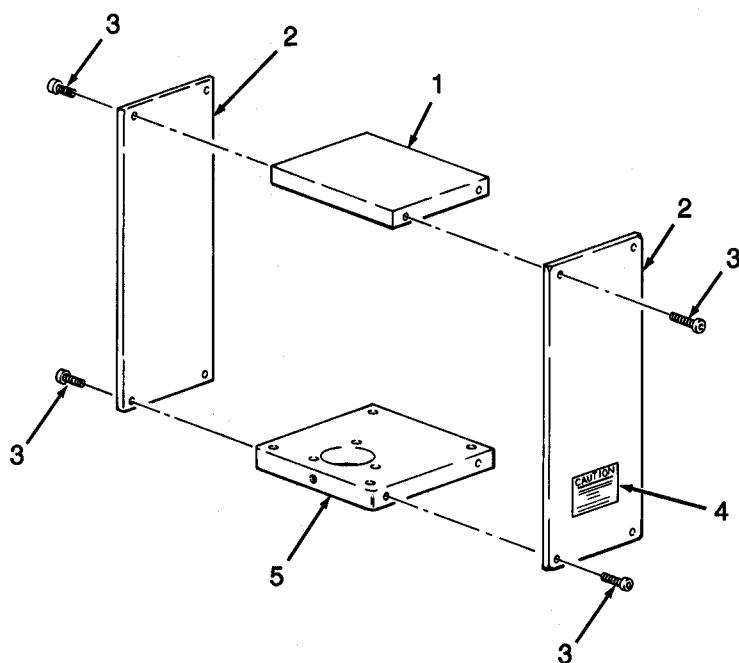
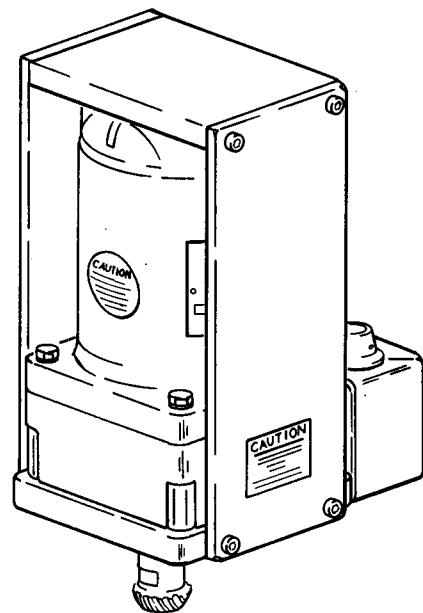
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Motor Mount

(Optional)

Illustrated Parts List

ITEM	PART NO.	DESCRIPTION	QTY.
1	62C12-12	Mounting Bracket, Top	1
2	62C12-11	Mounting Bracket, Side	2
3	308C18-3	Screw, Socket Hd. Cap 1/4-20 x 3/4	8
4	79C2-62	Label, Caution	1
5	29C6-174	Adaptor	1



Service Record

Machine Serial No.: _____

Machine Voltage: _____

Date of Purchase: _____

Date	Type of Service Performed

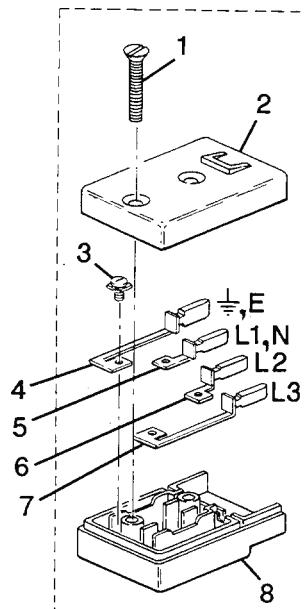
Troubleshooting:

Problem	Possible Causes	Remedy
To Little Lubrication	1. Lubrication Valve Close	1. Turn Lubrication Counterclockwise 2. Replace Lubrication Sponge
Difficulty Cutting	1. Increase Blade Speed. 2. Blade Dull 3. To Little Blade Lubrication 4. Excess Force While Cutting	1. Turn diode Indicator Clockwise 2. Sharpen Blade 3. Increase Flow of Blade Lubrication 4. Reduce Force pushing into material
Excess Blade Lubrication	1. Lubrication Valve Open	1. Turn Lubrication Valve Clockwise

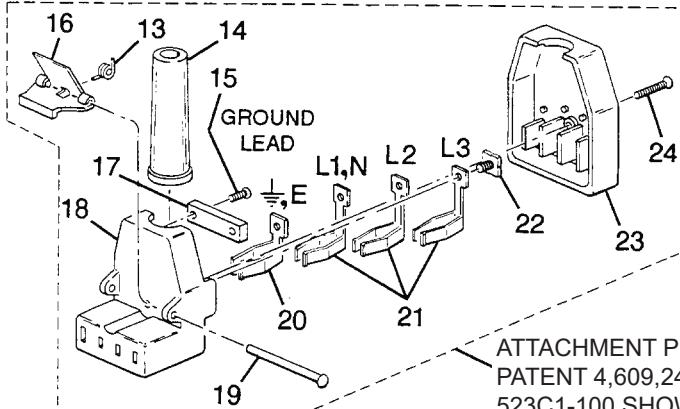
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Electrical Connections



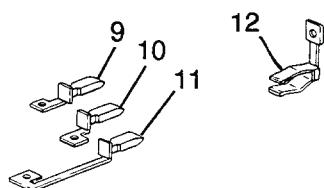
TERMINAL BLOCK
PATENT 4,609,244
508C1-100 SHOWN



ATTACHMENT PLUG
PATENT 4,609,244
523C1-100 SHOWN

WARNING

Electrical connections to this machine must be made by a qualified electrician ONLY. Failure to follow applicable codes and regulations and conduct a ground lead to terminal "E" on the attachment plug may result in serious personal injuries. For user safety, connect a ground lead to terminal "E" on the attachment plug. Always unplug the machine before performing maintenance, adjustment or repairs.



ITEM	PART NO.	DESCRIPTION
1	302C15-8	Screw, 10-32 x 1 1/8 Flat Hd.
2	-----	Terminal Block Top
3	20C13-103	U-Lock Screw
4	667C1-22	Terminal Contact w/Pin E
5	667C1-23	Terminal Contact w/pin L1, N
6	667C1-24	Terminal Contact w/Pin L2
7	667C1-25	Terminal Contact w/Pin L3
8	51C1-61	Terminal Block Bottom
9	667C1-26	Terminal Contact w/Pin L1, N
10	667C1-27	Terminal Contact w/Pin L2
11	667C1-28	Terminal Contact w/Pin L3
12	47C3-21	Terminal Sleeve (current)
13	34C10-170	Spring
14	1C13-27	Cord Sleeve
15	300C8-2	Screw, 4-40 x 1/2 Round Hd.
16	98C4-37	Thumb Clip
17	50C7-27	Cord Clamp
18	-----	Attachment Plug Body
19	91C4-22	Rivet
20	47C3-19	Terminal Sleeve
21	47C3-20	Terminal Sleeve (current)
22	20C13-103	U-Lock Screw
23	-----	Attachment Plug Cover
24	302C8-8	Screw, 4-40 x 7/8 Flat Hd.
25	-----	Terminal Block Complete
26	-----	Attachment Plug Complete

EASTMAN 10A 380V 3~	EASTMAN 10A 220V 3~	EASTMAN 10A 220V ~	EASTMAN 15A 120V ~	EASTMAN 25A 42V ~
E L1, N L2 L3	E L1, N L2 L3	E L1, N L2	E L1, N L2	E L1, N L3